



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-251
Job Sheet 198746



Part No: D206-642-251

Job Qty: 1 pcs

Part Name: Replacement Skidtube, High Gear with Run-on Landing Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/30/19

Description: order 18566

Type: SOLD

Note: DWG D3804 REV A (DEO), IIN-D206-642 REV Q SHEETS 13,28 IPP REV:A 11.11.17 PER IIN REVO DD
VERF;EC IPP Rev:B 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:C 14.04.25 ECN14-520 DD
verf:JLM IPP Rev:D 16.04.04 as per CHG004(ecn16-553) DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	8/30/19		0.00	3.00	Skidtubes - 1		QC
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	1 pcs	8/30/19		0.00	0.00	QC 5 - 10		AUG 22 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 4		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
130	QC 9	1 pcs	8/30/19		0.00	0.00			

PRIORITY

Container No: S206911

Part: D206-642-251

Job No: 198746

Serial No/Batch: S206911

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SA00475SE 18/10/17, 16, STC SH98 -

DART AEROSPACE
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
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AUG 22 2019

30

				QC 9 - 50	
				QC 9 - 9	
140	Handfinish - 1-1 Chemical-B4B	1	8/30/19	0.00 1.05	Handfinish - 1 - 1 - B4B
	pcs				Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
150	QC 7	1	8/30/19	0.00 0.00	QC 7 - 10
	pcs				QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50

BEB 19-08-23

MGC

					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
160 Skidtubes - 2 - B4B	1 pcs	8/30/19	0.00 3.38		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
180 Skidtubes - 3 - B4B	1 pcs	8/30/19	0.00 3.38		Skidtubes - 1 - B4B	
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
190 QC 5	1 pcs	8/30/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	BE
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
200 Skidtubes - 4 - B4B	1 pcs	8/30/19	0.00 3.38		Skidtubes - 1 - B4B	00
					Skidtubes - 2 - B4B	
					Skidtubes - 3 - B4B	
					Skidtubes - 4 - B4B	
					Skidtubes - 5 - B4B	BE
					Skidtubes - 6 - B4B	
					Skidtubes - 7 - B4B	
220 QC 9	1 pcs	8/30/19	0.00 0.00		QC 9 - 10	
					QC 9 - 18	DAS
					QC 9 - 24	24
					QC 9 - 43	9-89
					QC 9 - 50	
					QC 9 - 9	
230 QC 5	1 pcs	8/30/19	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	

					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS SEP 18 2019 68 9-89
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
240	Handfinish - 2-1 Pressure- B4B	1 pcs	8/30/19	0.00 1.05	Handfinish - 2 - 1 - B4B	
					Handfinish - 2 - 2 - B4B	SEP. 18 2019
					Handfinish - 2 - 3 - B4B	
					Handfinish - 2 - 4 - B4B	
250	Powdercoat - 1 White GI(A)- B4B	1 pcs	8/30/19	0.00 0.22	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	BK 19 9-19
					Powdercoat - 4 - B4B	
260	QC 3	1 pcs	8/30/19	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	HL 14-9-19
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
270	Handfinish - 4-1-Assembly- B4B	1 pcs	8/30/19	0.00 1.05	Handfinish - 4 - 1 - B4B	HL 14-9-19
					Handfinish - 4 - 10 - B4B	
					Handfinish - 4 - 11 - B4B	
					Handfinish - 4 - 12 - B4B	
					Handfinish - 4 - 13 - B4B	
					Handfinish - 4 - 14 - B4B	
					Handfinish - 4 - 15 - B4B	
					Handfinish - 4 - 2 - B4B	
					Handfinish - 4 - 3 - B4B	
					Handfinish - 4 - 4 - B4B	
					Handfinish - 4 - 5 - B4B	

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280 Handfinish - 4-2-Assembly-B4B	1 pcs	8/30/19	0.00 3.14	Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				Handfinish - 4 - 1 - B4B	
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	2114-8-19
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
290 QC 3 N/A DA	1 pcs	8/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
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				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
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				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
300 QC 5	1 pcs	8/30/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
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					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
310	Packaging 3-1 - Stock - B4B	1	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
	pcs				Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
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					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
315	DC - 1 - B4B	1	8/30/19	0.00 0.00	DC - 1 - B4B	
	pcs				DC - 2 - B4B	
320	QC 21 - FG	1	8/30/19	0.00 0.00	QC 21 - FG - 21	
	pcs				QC 21 - FG - 70	

DAS
40
9-89

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Part Op 110 - Skid tubes - 1-Debur Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld
 Descriptions: Fwd Cap as per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required. Pick: Qty Part Number Description Batch
 A/R Aluminum Rod 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per dwg D3804 from front of tube and Debur 6-Remove inner indexing ridge on Aft end of skid tube as per Dwg D3804 7-Open holes for Aft end cap as per Dwg D3804 with #30 Drill Bit using DT8025. 8-Drill pilot holes using Dt 8167, including #30 pilot at 1.25" from 15.450". Most fwd x-bolt hole must be laid out manually at 78.04". 9-Locate DT8732A from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732B & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732A & doubler leaving DT8732B for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the s
 120 - QC5- Inspect part completeness to step on W/O
 130 - QC9- Inspect visual per QSI004- Fusion Welds
 140 - Chemical Conversion Coat per QSI005 4.1
 150 - QC7-Inspect Chemical Conversion Coat
 160 - Skid tubes 1-Open holes to finished size to detail "B" as per Dwg D3804, (without cutting fluid) 2-C'sink ONE crossbolt spacer hole as per Dwg D3804 (Detail B)(without cutting fluid) 3-Debur and blow out all chips from inside the

tube

180 - Skidtubes - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting Start Date: _____ Time: _____

Finish Date: _____ Time: _____ Pick: Qty Part Number Description Batch A/R Sikaflex-291

Sikaflex expire date: 3200625 07256020

190 - QC5- Inspect part completeness to step on W/O

200 - Skidtubes 1-Remove alodine per DEO detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. Pick: Qty Part Number Description Batch A/R Aluminum Rod

13901 / 138989 3-Grind welds flush as per Dwg D3804. 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D3804. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. A/R SS Rod

5-Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002 6- Deburr

220 - QC9- Inspect visual per QSI004- Fusion Welds

230 - QC5- Inspect part completeness to step on W/O

240 - Pressure Wash per QSI005 4.3/ Clean and remove all markings

250 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____

260 - QC3- Inspect Part Finish

270 - HandFinish4 (Assemble as per dwg 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - HandFinish4 (Assemble as per dwg -1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive A/R Sikaflex-291 3200625 Sikaflex expire date: 20-7-25 2- Install wearplate as per dwg 2-Wing Walk as per Dwg D3804 and QSI 005 4.4 Batch: 5209367

290 - QC3- Inspect Part Finish

300 - QC5- Inspect part completeness to step on W/O

310 - Identify and pack for shipping as per PPP D206-642-251 Location: _____ PPP Rev: _____

315 - Document Control Photocopy bluefile & type labels per PPP D206-642-251 CHG004

320 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation
CCR264SS3-3 <u>320</u>	Cherry Rivet	2 Ea (2 ea)	110-Skidtubes - 1
CR3212-4-03 <u>270</u>	Cherry Rivet	2 Ea (2 ea)	110-Skidtubes - 1
CR3212-4-04 <u>200</u>	Cherry Rivet	<u>59</u> 52 Ea (52 ea)	110-Skidtubes - 1
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1
D2654-3 <u>200</u>	Web	1 pcs (1 ea)	110-Skidtubes - 1
D3286-1	Doubler	2 pcs (2 ea)	110-Skidtubes - 1
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skidtubes - 4 - B4B
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes - 4 - B4B
D4720-1	Spacer	19 pcs (19 ea)	200-Skidtubes - 4 - B4B
AN3-37A	Bolt	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B
D2651-1	Plug	8 pcs (8 ea)	270-Handfinish - 4-1-Assembly-B4B
D2651-3	O-Ring	8 pcs (8 ea)	270-Handfinish - 4-1-Assembly-B4B
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B
D3805-043	Run-on Landing Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B
D3805-047	Run-on Landing Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 4-1-Assembly-B4B
D3873-1	Bushing	14 pcs (14 ea)	270-Handfinish - 4-1-Assembly-B4B
MS21042L3	Nut	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B
MS27039-1-08	Screw	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B
MS27039-4-06	Screw	1 Ea (1 ea)	270-Handfinish - 4-1-Assembly-B4B
NAS1149C0332R	Washer (AN960C10L)	7 Ea (7 ea)	270-Handfinish - 4-1-Assembly-B4B
NAS1149D0332J	Washer	2 Ea (2 ea)	270-Handfinish - 4-1-Assembly-B4B
NAS1149D0463J	Washer	1 Ea (1 ea)	270-Handfinish - 4-1-Assembly-B4B
D2646	Aft Cap	1 pcs (1 ea)	280-Handfinish - 4-2-Assembly-B4B

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Container

504957

F119017

5161483

5189572

5166098

5167121

5176117

5199364

5178032

5214378

5210678

5196041

5180320

5197616

5213517

5214526

5209430

5201283-2

5162897

5166924-1

5193136

5178378

5158582

5160602

011999

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	CCR264SS3-3	2	105	0
	CR3212-4-03	2	64	0
	CR3212-4-04	52	313	0
	D2620	1	7	0
	D2647	1	32	0
	D2654-3	1	6	0
	D3286-1	2	24	0
200-Skidtubes - 4 - B4B	D2649	1	31	0
	D3286-3	2	8	0
	D4720-1	19	20	0
270-Handfinish - 4-1-Assembly-B4B	AN3-37A	7	77	0
	D2651-1	8	305	0
	D2651-3	8	225	0
	D2680-041	1	35	0
	D3805-043	1	1	0
	D3805-047	1	0	0
	D3873-1	14	56	0
	MS21042L3	7	725	0
	MS27039-1-08	2	411	0
	MS27039-4-06	1	86	0
	NAS1149C0332R	7	3,456	0
	NAS1149D0332J	2	2,549	0
	NAS1149D0463J	1	4,268	0
280-Handfinish - 4-2-Assembly-B4B	D2646	1	69	0
Part Specifications				
Specifications could not be found.				

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ITEM	Qty	Qty	Part Number	Description
1	X	-043	D3804-041	SKIDTUBE ASSEMBLY, 208 A/B LOW
2	X	X	D3804-043	SKIDTUBE ASSEMBLY, 208 A/B HIGH
6	1	1	D2600-1-180	EXTRUSION
8	1	1	D2648	AFT CAP
7	1	1	D2647	CAP
8	18	20	D2649	CROSS BOLT SPACER
9	8	8	D2651-1	PLUG
10	8	8	D2651-3	O-RING
11	1	1	D2654-3	WEB
12	1	1	D2654-1	WEB
13	1	1	D2690-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN860J0L	WASHER
22	1	1	AN860J0416	WASHER
23	2	2	CR2845S3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-08	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/281 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED "P" (BOTH SIDES OF TUBE)

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

TWO 1987-88 NOS 19-08-06

DEO ATTACHED

RELEASED
R 01-03-83
per E2-09-578

A	NEW ISSUE	DESCRIPTION	MB	08.07.07
REV.	BY	DATE		
DESIGN				
DRAWN				
CHECKED				
INFO. APPR.				
APPROVED				
DATE	08.07.07			

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D3804

TITLE SKIDTUBE ASSEMBLY, 208A/B

SCALE NTS

REVISIONS

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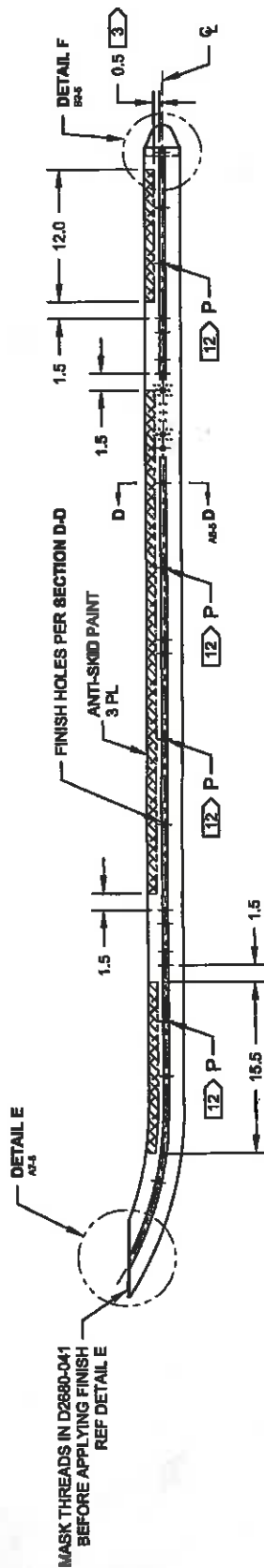
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REVISION 100 OF 5

DEO ATTACHED



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	<i>11</i>	DART AEROSPACE USA, INC
DRAWN	<i>11</i>	PORT HADLOCK, WA
CHECKED	<i>11</i>	DRAWING NO.
MFG. APPR.	<i>11</i>	D3804
DE APPR.	<i>11</i>	TITLE
DATE	<i>11</i>	SKIDTUBE ASSEMBLY, 206A/B
	<i>11</i>	REV. A
	<i>11</i>	SHEET 3 OF 5
	<i>11</i>	SCALE
	<i>11</i>	NTS
	<i>11</i>	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC
	<i>11</i>	THE INFORMATION CONTAINED HEREIN IS UNCLASSIFIED EXCEPT WHERE SHOWN OTHERWISE BY A DATE AND AUTHORITY

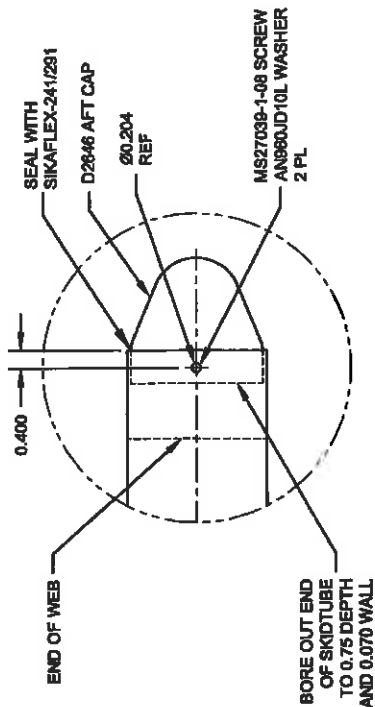
RELEASED

DEO ATTACHED

CR3212-4-03 RIVET
2 PL

CCR284SS3-3
RIVET
2 PL

VIEW G-G
SCALE NONE



DETAIL F
SCALE NONE

- D2847 CAP, TO INSTALL:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2847 (TRIM AS REQD)
 4. WELD D2847 IN PLACE
 5. GRIND FLUSH
 6. RIVET D2860-041 NUT PLATE IN PLACE

MS27039-4-08 SCREW
AN980JD416 WASHER
NUT PLATE

1.0 REMOVE RIDGE ON
INSIDE OF SKIDTUBE
LEAVE 0.070 MIN.

DETAIL E
SCALE NONE

DESIGN	41	DART AEROSPACE USA, INC
DRAWN	41	PORT NADLOCK, WA
CHECKED	41	DRAWING NO. D3804
INFG. APPR.	41	REV. A
APPROVED	41	SHEET 5 OF 5
DE APPR.	41	TITLE
DATE	08.07.07	SKIDTUBE ASSEMBLY, 206A/B
		SCALE
		NTS

NOT TO BE USED FOR ANY OTHER PURPOSES WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.

Entered:

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Skid-tube ☐ ☐ ☐ ☐ ☐ ☐ Machining ☐ ☐ ☐ ☐ ☐ ☐ Large Fab ☐ ☐ ☐ ☐ ☐ ☐ Cross tube ☐ ☐ ☐ ☐ ☐ ☐ Small Fab ☐ ☐ ☐ ☐ ☐ ☐ Finishing ☐ ☐ ☐ ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐ ☐ ☐ ☐ Engineering ☐ ☐ ☐ ☐ ☐ ☐ Water Jet ☐ ☐ ☐ ☐ ☐ ☐ Supplier ☐ ☐ ☐ ☐ ☐ ☐ Quality ☐ ☐ ☐ ☐ ☐ ☐				Date : _____ Sequence #: _____ QTY Affected : _____ MRB (QS1042) _____																											
Description Work Order Deviation		Disposition																																	
Completed By		Lead hand / Supervisor																																	
QC / QA Coordinator		_____																																	
Root Cause Operator ☐ ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐ ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table> Other/Details: _____						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																																
Mislabeled	Fit/Function	Off-set/Set-up																																	

191.

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Part Number: D206-642-251

Description: REPLACEMENT SKIDTUBE LH/RH

[illegible]